

Date: Monday, 1/7/2008 3:38:41 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 36636	
Estimate Number : 12719	
P.O. Number : N/A	Part Number : D353625
This Issue : 1/7/2008 S.O. No. : N/A	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 35566	Material : N/A
Written By : <u>JA 08.01.8</u>	Due Date : 1/21/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JA 08.01.8</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6254 sf(s)/Unit Total : 12.5076 sf(s)

NEOPRENE SHEET 0.063

Batch: 106614 IB 8-1-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

IB 8-1-9

(26)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-1-9

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

0860609 (26)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: finish

8/1/9 50

(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 36636

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



26

Comment: FINAL INSPECTION/W/O RELEASE

2008/1/11

Job Completion



2008/1/10

W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36636
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80				
16.35	+/-0.030	16.35				
10.90	+/-0.030	10.90				
5.45	+/-0.030	5.45				
6.00	+/-0.030	6.00	X			
6.75	+/-0.030	6.75	X			
12.75	+/-0.030	12.75	X			
1.89	+/-0.030	1.896	X			
0.30	+/-0.030	.30	X			
0.30	+/-0.030	.30	X			
Ø0.19	+0.005/-0.001	.189	X			

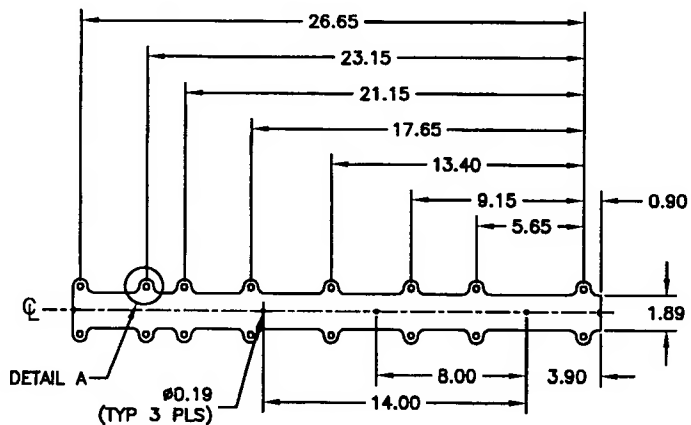
Measured by:	LB	Audited by:		Prototype Approval:	N/A
Date:	8-1-9	Date:	08/01/9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EA

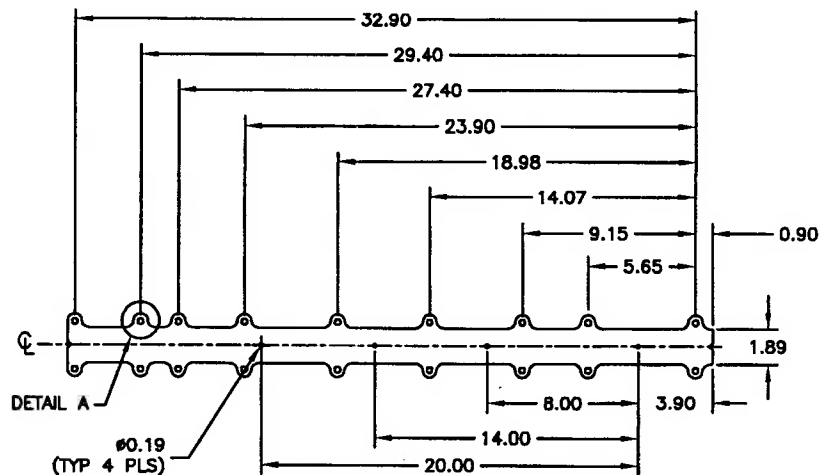
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
A	06.10.25	GASKET	NEW ISSUE	SHEET 1 OF 6
				SCALE 1:10

RELEASED
09.02.12



D3536-11 GASKET



D3536-13 GASKET

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NO WORK ORDER

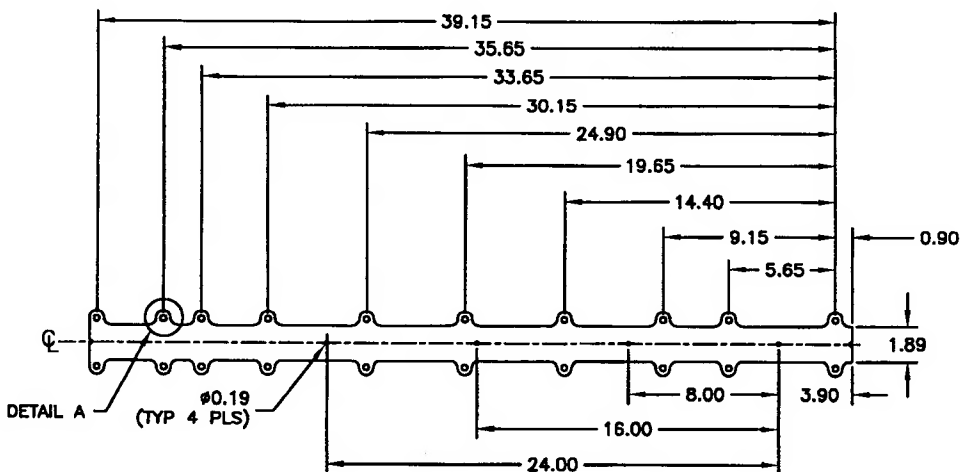
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

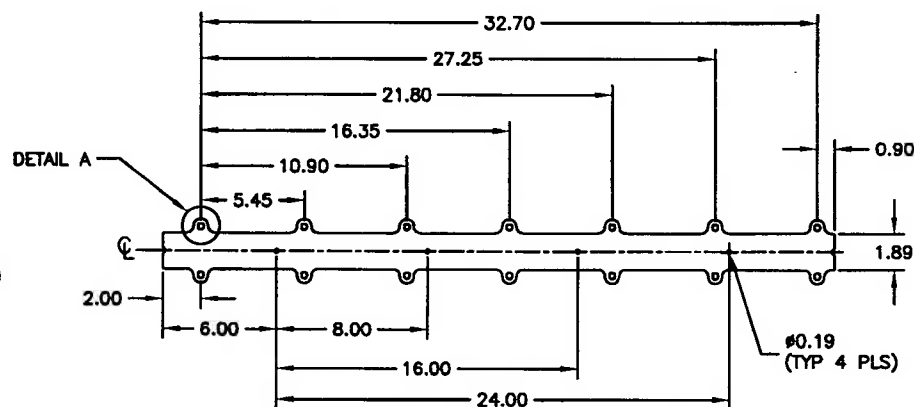
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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D3536-15 GASKET



D3536-21 GASKET

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NO. 36636

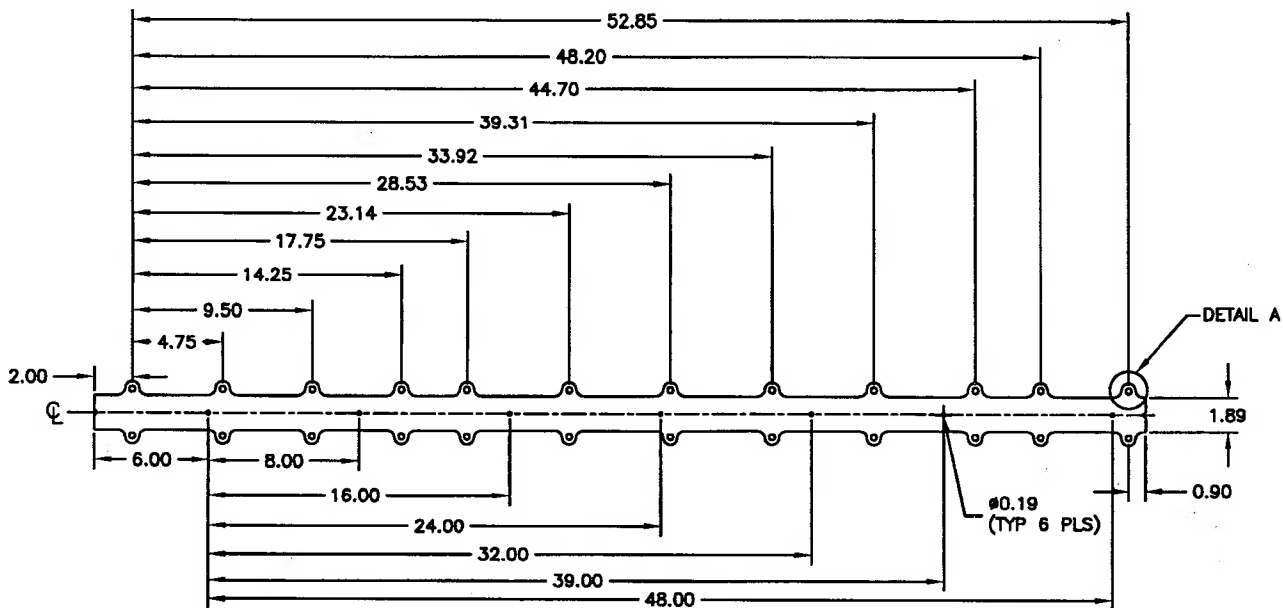
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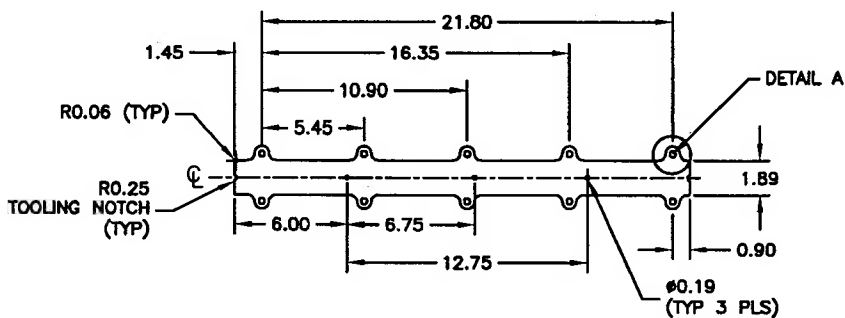
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CHECKED PH	APPROVED PH	DRAWING NO. D3536	SHEET 3 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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D3536-23 GASKET



D3536-25 GASKET

NOTES

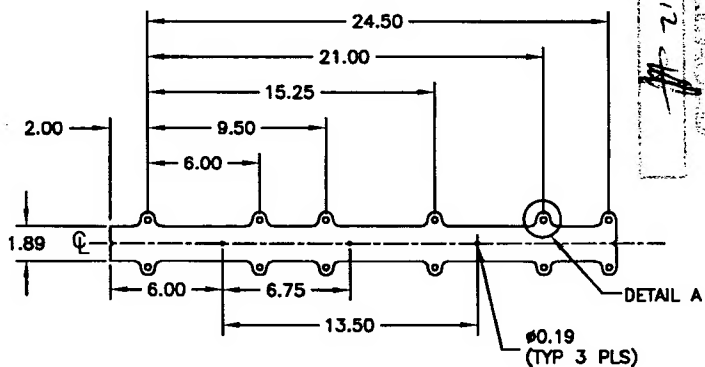
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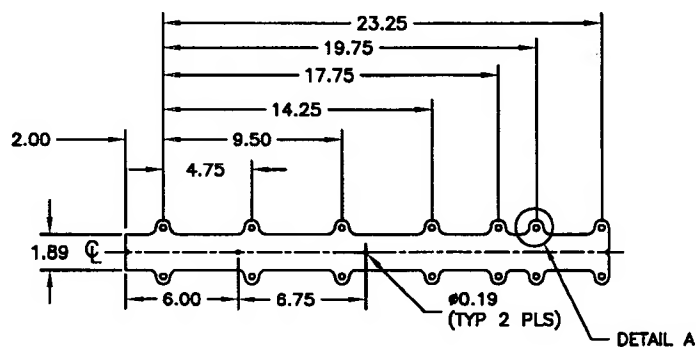


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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 4 OF 6
DATE	06.10.25	TITLE	GASKET	SCALE	1:10

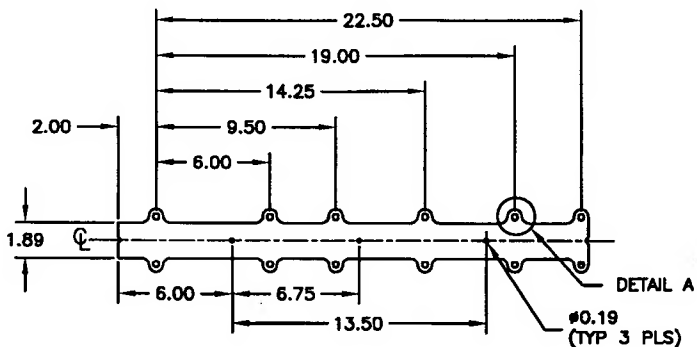
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

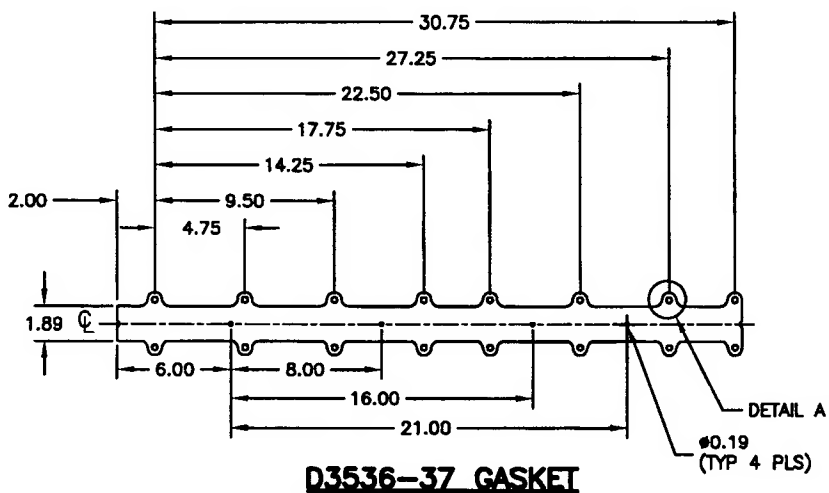
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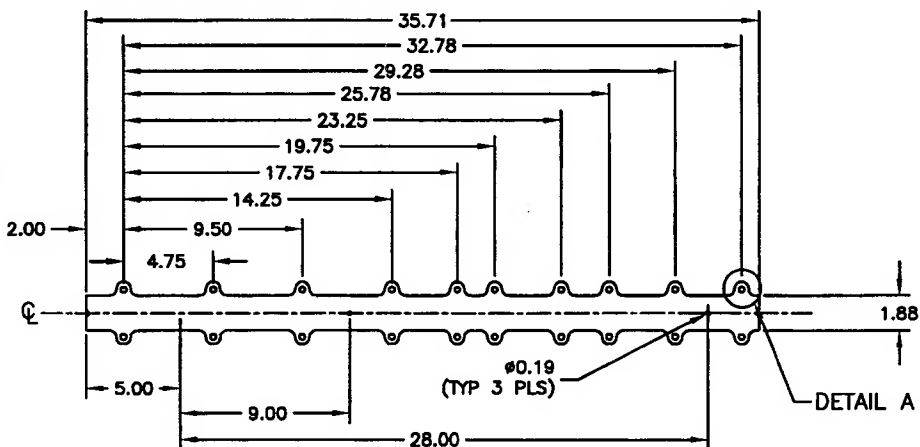
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DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	SCALE 1:10

07.02.02 **PH**



D3536-37 GASKET



D3536-39 GASKET

NOTES

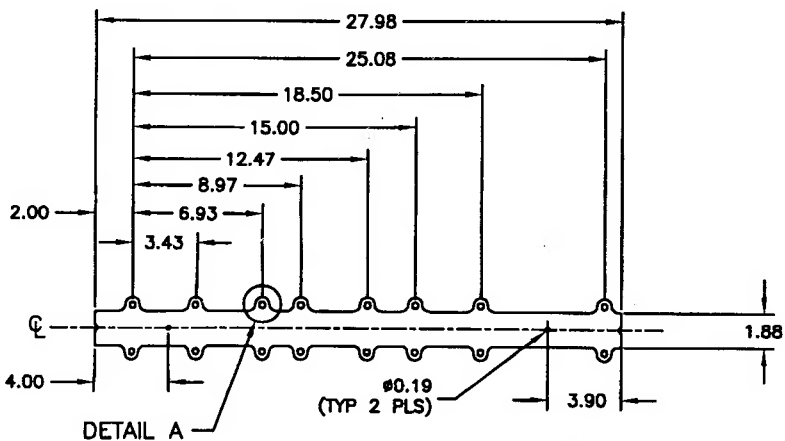
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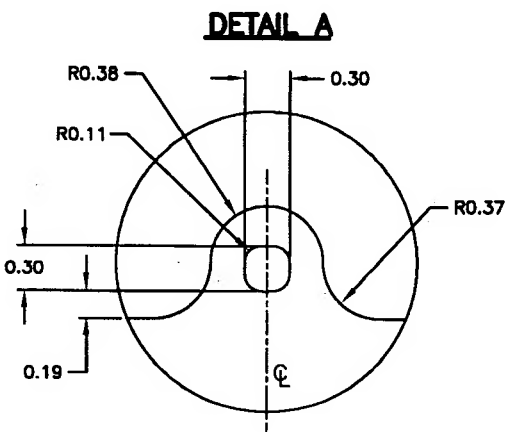
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. A
CHECKED PH	APPROVED PH	DRAWING NO. D3536	SHEET 6 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

RELEASED
070612 CH



D3536-41 GASKET



NOTES

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